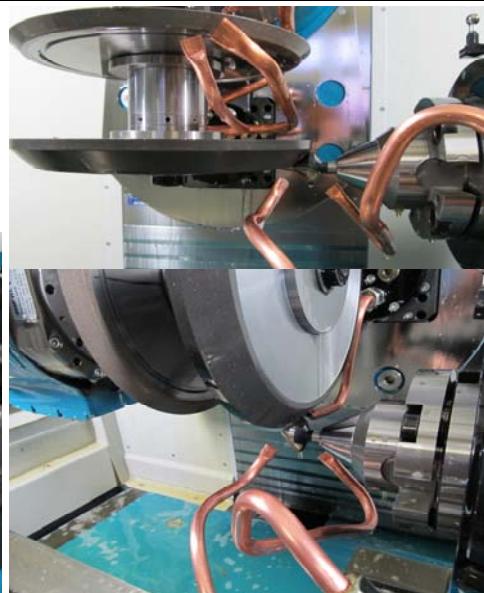


HSS Countersinkproduction Ø20 Z3

A06-310

HSS Countersinkproduction with CBN wheels can be achieved considerably fast, if the coolant pressure and quantity and the spindle power are large enough. The 3 operations flute - OD - End are shown in the pictures.



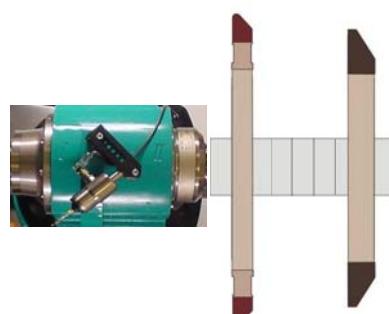
1. Cycletime for Production

Workpiece: Ø 20 mm, Z 3, Length 8 mm, Cam-relief: 0.5 to 1° Material HSS						
Operations	Probe	Flute 1	O.D.1	End 1	Dress	Load
Feed [mm/Min]	2000	180	300	300	100	9000
Power [kW]		16	2	1	2	1
Cutting feed [m/s]		42	32	32	32	
Used wheels		1	2	2	2	
Grinding time [s]	8	54	27	39	32	18
Total cycle time	2 Min 58					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø250 B126 45°
2	1V1 Ø250 B126 45°



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR 26 Coolant: Synthetic Oil, pressure 16 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Robot, dress

Responsible engineer: OP. 14.4.11

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